

Work Order ID 143667-1

143667

Page 1

March 18, 2016 10:32:03 AM

Item ID: D350-567-031

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Interior Window For -015 & -025

Start Date: 3/21/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/23/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 20160318 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D350-567

E

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file and create labels per PPP D350-567-031 chg001

Smb
16/3/22

MCS 16-03-21

110

Packaging

0.00

110

Packaging

Memo

0.00

Packaging

Pick Packing Kit

ENSURE DT 8439 TEMPLATE IS INCLUDED

1 MAD 21 2016

DAS
28
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

Smb
16/3/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 143667

143667

Page 2

March 18, 2016 10:32:04 AM

Item ID: D350-567-031

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Interior Window For -015 & -025

Start Date: 3/21/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/23/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-031								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

PPD 143667

BAS
27
9-59
MAR 22 2016

ML5

MAR 22 2016

ML5

MAR 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

March 18, 2016 10:33:12 AM

Page 1

Work Order ID: 143667

143667

Parent Item: D350-567-031

D350-567-031

Parent Item Name: Interior Window For -015 & -025

Start Date: 3/21/2016

Required Date: 3/23/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-04-25 DD verified by: LL
IPP Rev:B 08-10-07 as per revD DD verified by:
13.10.15 AS PER IIN REV.E DD VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C632R12

Purchased

No

120

Each

230.0000

8

16

AN526C632R12

Screw

**

DAS

8

9-89

28

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST327

230

m133234 8x

30

m134180

200

16

D2463

Manufactured

No

120

f

510.7459

3.75

3.75

D2463

1/2" Seal (SPer Foot)

**

DAS

8

9-89

28

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST409

500

140013

500

ST638

10.74591044

125469

10.7459104

(D2463-0450) CUT (1) AT 45.00" ASPER DWG

PER KIT

D3210-1

Manufactured

No

120

Each

11.0000

1

12

D3210-1

Doubler For Interior Window -015 & -025

**

DAS

8

9-89

28

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST442

11

130478

11

2

MAR 21 2016

Picklist Print

March 18, 2016 10:33:12 AM

Page 2

Work Order ID: 143667

143667

Parent Item: D350-567-031

D350-567-031

Parent Item Name: Interior Window For -015 & -025

Start Date: 3/21/2016

Required Date: 3/23/2016

Start Qty: 1.00

Required Qty: 1.00

D3211-1 Manufactured No

120 Each 1.0000

D3211-1

Bracket For Interior Window For -015 & -025

**

Location

Loc Qty

Loc Code

ST438

1

129526

1

D3212-1 Manufactured No

120 Each 6.0000

D3212-1

Replacement Interior Window For -015 & -025

**

Location

Loc Qty

Loc Code

ST437

6

113221

2

113831

4

D3213-041 Manufactured No

120 Each 8.0000

D3213-041

Replacement Interior Door For -015 & -025

**

Location

Loc Qty

Loc Code

ST437

8

134574

8

MS20470AD4-5 Purchased No

120 Each 1,176.000

MS20470AD4-5

RIVET, UNIVERSAL HEAD

**

Location

Loc Qty

Loc Code

GA

914

m133860

914

ST310

262

m133860

262

MAR 21 2016

Picklist Print

March 18, 2016 10:33:12 AM

Page 3

Work Order ID: 143667

143667

Parent Item: D350-567-031

D350-567-031

Parent Item Name: Interior Window For -015 & -025

Start Date: 3/21/2016

Required Date: 3/23/2016

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-6

Purchased

No

120

Each

2,378.000

90

90 180

MS20470AD4-6

RIVET

**

DAS
8
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK004

1566

m134360

1566

GA

471

m131618

93

m133077

378

ST310

341

m133077

341

180

MS20470AD4-7

Purchased

No

120

Each

2,475.000

20

20 40

MS20470AD4-7

Rivet, Universal Head

**

DAS
8
9-89
28
9-89

Location

Loc Qty

Loc Code

CCK007

1396

m134376

1396

ST310

1079

m132536

1079

40

MS21042L06

Purchased

No

120

Each

166.0000

8

8 10 16

MS21042L06

Nut

**

DAS
8
9-89
28
9-89

Location

Loc Qty

Loc Code

ST303

166

m134063

16

m134294

100

m134474

50

16

DAS
27
9-89

MAR 21 2016

Picklist Print

March 18, 2016 10:33:12 AM

Page 4

Work Order ID: 143667

143667

Parent Item: D350-567-031

D350-567-031

Parent Item Name: Interior Window For -015 & -025

Start Date: 3/21/2016

Required Date: 3/23/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN632J

Purchased

No

120

Each

777.0000

8

8.14

NAS1149DN632.J

Washer

Location

Loc Qty

Loc Code

ST264

777

m133860

77

m134370

700

DAS
6 28
9-08 9-08

MAR 21 2016

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
		9	8		AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
		9	8		AN960JD6	WASHER
		9	8		MS21042L06	NUT (OR MS21042-06)
		2	40		MS20470AD4-5	RIVET
		115	90		MS20470AD4-6	RIVET
		15	20		MS20470AD4-7	RIVET

• COPYRIGHT © 2000 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E
Date: 13.08.15